

Work Order ID 126359

November-05-14 8:54:54 AM

\*126359\*

Page 1

Item ID: D2583

Revision ID:

Item Name: Latch Bracket

Start Date: 11/14/14 Start Qty: 50.00

Required Date: 11/14/14 Req'd Qty: 50.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2583

Rev B

100

0.00

\*100\*

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583 Dwg Rev: B Prog Rev: B 2-  
Debur if necessary

50

0

DAS

23

9-89 14-11-05

110

0.00

\*110\*

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

50

0

DAS

23

9-89 14-11-05

120

0.00

\*120\*

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

4/9

DAS

38

9-89

NOV 05 2014

# Work Order ID 126359

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Item ID: D2583 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Latch Bracket  
 Start Date: 11/14/14 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 11/14/14 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	NC BRAKE				DAS				14/11/05
Brake NC	Memo	0.00			30	49			
Brake NC	DeburrForm on CNC Brake as per Dwg D2583				9-89				
140									
<b>*140*</b>	QC5- Inspect part completeness to step on W/O	0.00							DAS
QC	Memo	0.00							38
Quality Control									9-89
150									
<b>*150*</b>	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

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# Work Order ID 126359

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Item ID: D2583 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Latch Bracket  
 Start Date: 11/14/14 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 11/14/14 Req'd Qty: 50.00 **\*50\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum <i>11/29/08</i> Memo START TIME: <i>8:25</i> OVEN TEMPERATURE: FINISH TIME: <i>8:55</i>	0.00 0.00				<i>49</i>	<i>14-11-7</i>		<i>DAS 34 9-89</i>
170 <b>*170*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				<i>(49)</i>			<i>DAS 38 9-89</i>
180 <b>*180*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>5481</i>  Memo	0.00 0.00				<i>49x</i>			<i>DAS 26 9-89</i>

NOV 10 2014

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**Work Order ID 126359****\*126359\***

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Item ID: D2583 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Latch Bracket  
Start Date: 11/14/14 Start Qty: 50.00 **\*50\*** Cust Item ID:  
Required Date: 11/14/14 Req'd Qty: 50.00 **\*50\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

MF  
14-11-11

# Picklist Print

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Work Order ID: 126359

**\*126359\***

Parent Item: D2583

**\*D2583\***

Parent Item Name: Latch Bracket

Start Date: 11/14/14

Required Date: 11/14/14

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat- in house processDM  
IPP: D06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040

Purchased

No

100

sf

91.5400

0.1169

7

**\*M5052H32S 040\***

★★

DAS

23

14-11-05

5052-H32 .040 Sheet

9-8

Location

Loc Qty

Loc Code

MAT022

91.54

122406

6.64

124445

1.4

m128852

4.5

m129530

79

129530

126359

☒ First Article ☐ Prototype

**DAS**  
**23**  
0.80

DAS	
Audited by:	38 9-89
Date:	NOV 05 2014

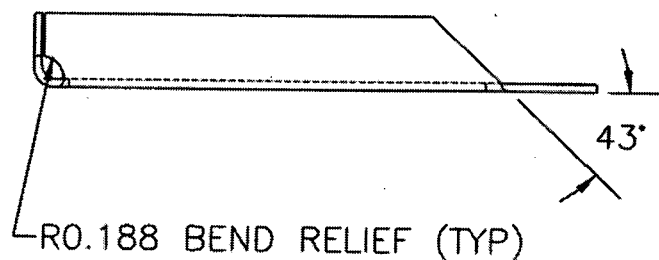
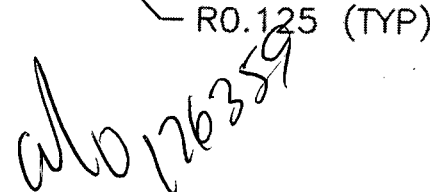
~~NOV 05 2014~~

Revised by	Approved
KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

QA COPY 15000

RELEASE  
KE 99.02.25

DESIGN		DRAWN BY		DART AEROSPACE LTD	
MIKE M.		RF		HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
QP	KE	D2583		SHEET 1 OF 1	
DATE		TITLE		SCALE	
99.02.22		LATCH BRACKET		2:3	
A	96.07.10	NEW ISSUE			
B	99.02.22	CHANGE OF FINISH		(PER TSR A887)	



0.600 (TYP) —  
R0.125 (TYP)

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

# ENGINEERING CHANGE NOTICE

## DART AEROSPACE LTD

Date: 14.11.07	Job No.: ENG5100OCT	ADR Yes/No: Y	ADR Date: 14/11/20	ECN #: 14- 646
Product No.: D350-636-XXX	Created By: <i>[Signature]</i>	Approved By: <i>[Signature]</i>		
Product Name: SKIDTUBE INSTALLATIONS	Checked By: <i>[Signature]</i>			

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	NF	
Production Manager / Coord.	Y	LL/MF	
Purchasing Coord.	N	CL	
Production Engineering Coord.	Y	DD/JLM	
Production Engineering Coord.	N	DL	
Customer Order Processing	N	RM/CC	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS/ED	
QC Coordinator	Y	PD	
Customer Support	Y	SW/LM	
Customer Technical Support	Y	MB/HS	
Marketing	Y	KO/SL	
Sales Support Manager	Y	CP	

**Reason for Change:**  
TO ADDRESS PAR14-371 (REF. CASE 8527).

**Documents Affected:**  
RELEASE DSI 9711 REV. A

IF APPLICABLE:    NCR: \_\_\_\_\_    PAR: 14-371    CAR: \_\_\_\_\_    CIR: \_\_\_\_\_    URF: \_\_\_\_\_

PAPERWORK UPDATE    ☒    PARTS MUST COMPLY    ☐    PREVIOUS PARTS SATISFACTORY    ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	Y	MB	SEE BELOW.	
2	Notify Eurocopter France	N			
3	Notify Augusta Westland	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Update Product Compatability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10					

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	KJ		14.11.7 <i>[Signature]</i>
12	Update Product Specification Files (Bluefiles)	Y	KJ		14.11.7 <i>[Signature]</i>
13	Update Approved/Preliminary Dwg PDF Files	Y	KJ		14.11.7 <i>[Signature]</i>
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	N			
17	Update / Verify Airworthiness Release Certificate Database	N			
18	Create / Update Change Record Form / Item Card Database	N			
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	Y	KJ		14.11.7 <i>[Signature]</i>
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	Y	KJ	WITH ADR.	14.11.7 <i>[Signature]</i>
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

**Description / Action:**  
REWORK ONLY REQUIRED FOR QTY(1) EACH D3488-041/-042 IN ACCORDANCE WITH DSI 9711 REV. A AND SHIP TO CUSTOMER. REF. SO118793.  
  
NOT MANDATORY TO UPDATE PAPERWORK OF KITS IN STOCK.

ECN Verified & Complete: \_\_\_\_\_ Date: \_\_\_\_\_